110

110

Quality Control

Work Order			*98 2	171*						Page 1
Item ID: D Revision ID:	03929-041		Accept	*N900	040	100)*	Setup Sta	I A	S1*
Item Name: G	Susset Assembly	1)						Sto	^b *N	S2*
Start Date: 3/	/15/13 Start Qty: 6/00 /22/13 Req'd Qty, 6/00	* 5*/		Cust Item I	D:					
Required Date: 3/Reference:	/22/13 Req'd Qty/6/00	*/5/*		Customer:						
Approvals:	Process Plan: ML5	Date: /3-03-	73 Tooling:	Da	ate:	~	F	Run Sta	1/1	R1*
	QC:			D:	ate:			Sto	*N	R2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr									
D3929	Rev A									
100			0.00							
100 Waterjet	Memo		0.00				24	٥		JM3-3-21
FLOW CNC Waterjet	I-Cut as pe Dwg Rev:_	r Dwg D3929								
304,125	Prog Rev:								¥	,
	2-Deburr if	necessary							W.	
	•			•						

Jm13-3-21

0.00

0.00

QC2- Inspect parts off machine FAI/FAIB

Memo

											DQA:	D	ate:	
NCR: Y	es / No				WORK ORDER NON-O		NFORM	MANCE / UP	DATE		QA Closed:	D	ate:	
Work Orde	,				DISPOSITION	AGAINST				DE	PARTMENT	/PROCESS		
Part No	o	1 . 1 . 1			Rework Scrap Use-as-is Work Order Update	Scrap Machining Sm Use-as-is Thermoforming Fi			Crosstube Small Fab Finishing Composite		Pro Rec/Sto	Engineering Quality Other		
Root				Descri	ption of work order update	П	nitial	Act	tion		Sign &			
Cause	Date	Step	Qty	·	or Non-conformance	Ch	ief Eng	Desc	ription		Date	Verification	on	QC Inspector
Ooc/Data Equip/Tooling Operator Material Setup Other Process Supplier Fraining Unapproved				:		•		;						
		1			F	AUL	T CATE	GORY			<u> </u>			
Landin	g Gear	· · · · · · · · · · · · · · · · · · ·			General									
	Bending Centre N Cracks Crushed/ Cuffs Heat Trea	Crimped		o/s	Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		1	on Incomplete ions Incomplete/l nance led	Jnclear		Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned W Power Loss/	ct ssing Vrong		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
ſ	Ripples in	n Bend			Drill Holes		Offset		_		_			<u></u>

Out of Calibration

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

150

QC

Large Fab

Quality Control

Memo

QC9- Inspect visual per QSI004- Fusion Welds

Weld bushings D3907-1 as per dwg D3929

316L rod batch: M/22357

0.00

0.00

13.03.2

									DQA:	Date:	
NCR: Ye	s / No				WORK ORDER NON-C	ONFOR	MANCE / UPDAT		QA Closed:	Date:	
Work Order:	:				DISPOSITION		•	AGAINST DEI	PARTMENT	/PROCESS	
Part No NCR No					Rework Scrap Use-as-is Work Order Update		Machining S noforming	rosstube Small Fab Finishing omposite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	Initial	Action		Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chief Eng	Descriptio	on	Date	Verification	QC Inspector
Doc/Data				· · · · · · · · · · · · · · · · · · ·							
Equip/Tooling	-										
Operator	1								,	,	
Setup	-{	ì	1				İ				

FAULT CATEGORY Landing Gear General Bending Bend Grain Ovalized Pressure/Forced Centre Not Concentric to O/S BOM/Route Over/Under tolerance Temperature/Cure Hardware Broken/Damaged Weld Cracks Inspection Incomplete Part Incorrect Instructions Incomplete/Unclear Crushed/Crimped Part Lost/Missing Burrs Wrong Stock Pulled Cuffs Contamination Maintenance Part Moved Heat Treat Countersink Mislabeled Positioned Wrong Inspection Strip in Tube **Cut Too Short** Misread Power Loss/Surge Other Ripples in Bend Drill Holes Offset Torque Waves in Extrusion Drawing Out of Calibration Turning Sequence Finish Out of Sequence Wave/Twist in Tube Folio **Outside Dimensions**

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Other
Process
Supplier
Training
Unapproved

Work Ord		8471			*984	L71*						Page
Item ID: Revision ID: Item Name:	D3929-041 Gusset Asser	•			Accept	*N900	040	100)* s	etup Star Stop	1.71	S1* S2*
Start Date: Required Date Reference:	3/15/13	Start Qty: 6.00 Req'd Qty: 6.00		*6* *6*		Cust Item I Customer:	D:					
Approvals:	Process Pl	lan:	Date:		Tooling:		ate:		R	tun Star Stop	1/1	R1* R2*
Sequence ID/ Work Center I	D	Operation Description			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
*160 *160* QC		QC5- Inspect part comp	eleteness to step	on W/O	0.00				<u> </u>	13-03	.27	09
Quality Control												ΩA

170

Identify as per dwg & Stock Location: WADDY

0.00

170 Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00

180

Memo

0.00

Quality Control

@ 13-03-27

MC5 13-03-27

Page 3

NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UP	DATE		•			• .
												QA Closed:	Da	te:	₹ ¹
Work Orde	er: _					DISPOSITION	_					PARTMENT,			🗀
Part NCR N	-		4			Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstub Small Fa Finishin Composit	b g	4	Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other
Root					** **	ption of work order update	1	Initial	Ac	tion		Sign &			ū
Cause	\perp	Date	Step	Qty		or Non-conformance	Ch	nief Eng	Desc	ription		Date	Verificatio	n	QC Inspector
Doc/Data Equip/Tooling Operator							4.3	,	4.				·		
Material Setup Other	/ *	•							1.		÷	i per i			· ·
Process Supplier Training Unapproved		The second second			, 9 - ²				***		•		San Co		and Ref.
	•	9 +				F	AUL	T CATE	GORY						**
Landi	ng G	ear				General									'
		Bending Centre No Cracks Crushed/0			o/s	Bend BOM/Route Broken/Damaged Burrs		Instruct	on Incomplete ions Incomplete	'Unclear		Ovalized Over/Under Part Incorred Part Lost/Mi	ct		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
		Cuffs Heat Trea Inspection		Tube		Contamination Countersink Cut Too Short		Mainte Mislabe Misread	led			Part Moved Positioned V Power Loss/		Па	Other
	—	Ripples in				Drill Holes		Offset			<u> </u>				-
		Torque W			n _	Drawing		-i	Calibration		-				
		Turning So	equence		1	Finish	1	Out of S	Sequence						

Outside Dimensions

Date:

DQA:

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

Folio

Work Order ID:

98471

Parent Item:

D3929-041

Parent Item Name:

Gusset Assembly

Start Date: 3/15/13

Required Date: 3/22/13

Start Qty: 6.00

Required Qty: 6.00

Co		

Comments.														**
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measur		Qty per Kit	Total Qty	Qty Issued	Date Issued	Status	
M304S11GA		Purchased	No			100	sf	258.0000	0.45	2.8421			Jm,3-3	-2
304/316 0.125 Sheet												<u>-:</u>		
	*			Location		Loc Oty	Ī	Loc Code	•					
				MAT020		258								
				122	521	66			193	150				
				244	45	192								
D3907-1		Manufactured	No			130	Each	92.0000	2	12				
Bushing												THE RESERVE OF THE PERSON NAMED IN		
				Location		Loc Qty	<u> </u>	Loc Code		4				
5 AAS				WA004		52					•			
B 9873				888	91	1								
				896	88	1								•
				952		15			-X	48_	13-0	93-2	7 MAL	<i>r</i> .
				(963	02 × 2	35						. 0.	,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,	
				WA007		40								·
				(96)	46 × 235	40								

										DQA:	Date	:
NCR: Y	es / No				WORK ORDER NON-C	10:	VFORM	AANCE / UP	DATE	QA Closed:	Date	· ::
Work Orde	or:				DISPOSITION			***	AGAINST D	EPARTMENT	/PROCESS	
Part N	lo				Scrap Machining Sm. Use-as-is Thermoforming Fir Work Order Update Large Fab Com			Crosstube Small Fab Finishing Composite	Pro Rec/Sto	Engineering Quality Other		
Root				Descri	ption of work order update	ı	nitial	Act	tion	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training												
Unapproved			<u> 1</u>			<u> </u>	T CATC				<u></u>	
Landie	ng Gear				General	AUL	T CATE	JURY				
Lanui	Bending Centre N Cracks Crushed, Cuffs Heat Tre	lot Conce /Crimped at on Strip ir		o/s	Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		Instruct Mainte Mislabe Misreac	on Incomplete ions Incomplete/l nance led	Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V	ct issing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	Ripples i	n Bend		- 1	Drill Holes	1	Offset		,			

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order:	14486
Description: Support Gusset	Part Number:	D3929-1
Inspection Dwg: D3929 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Dimension Ø0.375 0.500	+0.006/-0.001	Dimension	Accept	Reject	4 4	Comments
0.500					Inspection	
		0.376	٠		V	Ikmoi
0.500	+/-0.010	0.501"	4		V	
0.500	+/-0.010	0. 501,			V	
4.036	+/-0.010	4.036	-		- U	
4.382	+/-0.010	4,382°	•		V	
8.274	+/-0.010	8.274	•		V	Produser?
10.915	+/-0.010	10.914"	-		V	
1.000	+/-0.010	1.009"	ļ		V	
11.198	+/-0.010	11.1982	_		V	
0.500	+/-0.010	0,503"	-		V	
1.572	+/-0.010	1.580"	Name :	~	V	
0.125	+/-0.010	0.113"	-	·	V	
				4,		
						4.0
				_		
	_		QA.			

			777		
Measured by:	m	Audited by:	E.	Prototype Approval:	N/A
Date:	3-3-21	Date:	13321	Date:	N/A

Rev	Date	Change		Revised	lþу	Approved
Α	09.05.27	New Issue	P/O D3929-041/-042			

D3929-041 GUSSET ASSEMBLY **D3929-042 GUSSET ASSEMBLY**

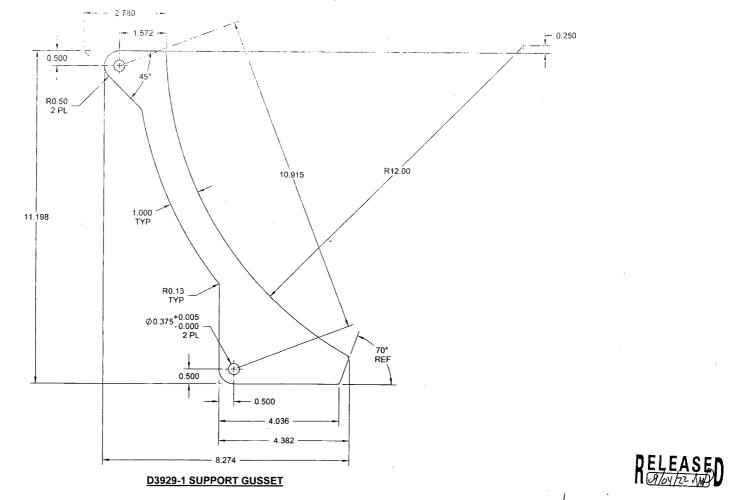
DESCRIPTION D3929-041 GUSSET ASSEMBLY D3929-042 GUSSET ASSEMBLY D3907-1 D3929-1 BUSHING SUPPORT GUSSE

> SHOPCOM RETURN: **ENGINEFRI.** at UNCONTROLLED SUBJECT TO AME also de WITHOUT COTICE WORK OR OF MLJ 13-03-13

Α	NEW ISSUE			MB	09.04.03
REV.			DESCRIPTION	BY	DATE
DESIGN DRAWN		4	DART AEROSPACE LTD		
				URY, ONTARIO, CAN	
CHECKED		Pet	DRAWING NO.		REV. A
MFG. APPR.			D3929	· ·	SHEET 1 OF 3
APPROVED		1 De la companya (Companya Companya Com	TITLE		SCALE
DE APPR.		#	GUSSET ASSEMBLY NT		NTS
DATE 09.04.03			COPYRIGHT TO 2009 BY DART AEROSPACE LTD 1165 COCUMENT 6 PRIVATE NO COMPONITY, NO ES SUPPLIED ON THE 92PRISES COMPONED THAT IT IS NOT TO BE USED TO MAY PURPOSE OF COPED OR COMMENCATED TO MAY OTHER PERSON WITHOUT MATTER THAT THE PERSON FOR USED AND MAY FOR MAY THE TO THE PERSON WITHOUT MATTER THAT THE PERSON FOR MAY PROVIDED AND MAY FOR MAY THE		

NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

5) IDENTIFICATION: IDENTIFY WITH DART P/N "D3929-04X" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.73 lbs EACH
8) WELDING: PER DART QSI 004



NOTES: 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524 11 GAUGE (0.125 THICK) REF. DART SPEC. M304S11GA

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.72 lbs

DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. A D3929 MFG. APPR. SHEET 3 OF 3 TITLE APPROVED SCALE GUSSET ASSEMBLY

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TO SEE MOST ONE WINDSTEE OF MICE PROSTORY OF WOMEN OF THE COPPRESS CONDITION THAT ITS

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